



Dart Aerospace Ltd.
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D5062-041
Job Sheet 191146



Part No: D5062-041

Job Qty: 12 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/22/19

Job Tracking No:

Due Date: 2/26/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A IPP REV:A 14.02.11 NEW ISSUE DD VERF:JLM IPP REV:B 14.05.28 AS PER DWG REV:A DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		2/26/19	0.00	0.74	Waterjet - Flow		DC 19/02/23
110	QC 2	12 pcs		2/26/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		DC 19/02/23
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

Rush!!!

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120	QC 8	12 pcs	2/26/19	0.00 0.00	QC 2 - 66	
					QC 2 - 64	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
130	Small Fab - Brake NC - B4B	12 pcs	2/26/19	0.07 3.66	Small Fab - Brake - 1 - B4B	
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	
140	QC 5	12 pcs	2/26/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
150	Handfinish - 1-1 Chemical-B4B	12 pcs	2/26/19	0.00 0.58	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	

DAS
40
9-89

DAS
36
9-89

DAS
30
9-89

19.02.25

D.R. 19/03/12

160 QC 7	12 pcs	2/26/19	0.00 0.00	Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
170 Small Fab - 2 - B4B	12 pcs	2/26/19	0.00 1.16	QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	SMB 19/3/13
				QC 7 - 59	
180 QC 5	12 pcs	2/26/19	0.00 0.00	QC 7 - 6	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				Small Fab - 1 - B4B	SMB 19/3/13
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				QC 5 - 10	
190 Spray Paint - 2 - B4B	12	2/26/19	0.00 1.01	QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	MAR 13 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				Spray Paint - 1 - B4B	RD 19-3-14

	pcs			Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
200 QC 14	12 pcs	2/26/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	DAS MAR 15 2019 68
210 Packaging 3-1 - Stock - B4B	12 pcs	2/26/19	0.00 0.00	Packaging 3 - 1 - B4B	9-89
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	ST-136
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	12 pcs	2/26/19	0.00 0.00	QC 21 - SA - 21	DAS 21 MAR 15 2019
				QC 21 - SA - 70	9-89
				QC 21 - SA - 53	
Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB) Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Bend/Assemble as per dwg) 140 - (QC5- Inspect part completeness to step on W/O) 150 - (Chemical Conversion Coat per QSI005 4.1) 160 - (QC7-Inspect Chemical Conversion Coat) 170 - (Small Fab) 180 - (QC5- Inspect part completeness to step on W/O) 190 - (Spray Paint / NDT Room) 200 - QC14- Inspect Spray Paint					

210 - Packaging3-2 (Identify as per dwg & Stock Location: _____)
 220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	2.4000 sf (.2 ea)	100-Waterjet - Flow - 1	511804
MS20470AD4-5	Rivet, Universal Head	48 Ea (4 ea)	170-Small Fab - 2 - B4B	5049829-1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.080	2	227	0
170-Small Fab - 2 - B4B	MS20470AD4-5	48	2,060	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket Assembly	0.098Inches + 0.004 - 0.001	0.102 0.097		
2	Bracket Assembly	0.750Inches ± 0.010	0.760 0.740		
3	Bracket Assembly	0.030Inches ± 0.030	0.060 0.000		
4	Bracket Assembly	1.000Inches ± 0.010	1.010 0.990		
5	Bracket Assembly	1.750Inches ± 0.030	1.780 1.720		
6	Bracket Assembly	3.940Inches ± 0.030	3.970 3.910		
7	Bracket Assembly	4.330Inches ± 0.030	4.360 4.300		
8	Bracket Assembly	5.080Inches ± 0.030	5.110 5.050		
9	Bracket Assembly	9.460Inches ± 0.030	9.490 9.430		
10	Bracket Assembly	1.160Inches ± 0.030	1.190 1.130		
11	Bracket Assembly	1.360Inches ± 0.030	1.390 1.330		
12	Bracket Assembly	4.0400Inches ± 0.0300	4.0700 4.0100		
13	Bracket Assembly	2.950Inches ± 0.030	2.980 2.920		
14	Bracket Assembly	4.330Inches ± 0.030	4.360 4.300		
15	Bracket Assembly	5.510Inches ± 0.030	5.540 5.480		

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Container No: S155942



Part: D5062-041

Job No: 191146

Serial No/Batch: S155942

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/23/19